

Date: Thursday, 5/4/2006 11:14:10 AM  
 User: Kim Johnston

# Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BLOWER INLET ADAPTER  
 Job Number : 26956  
 Estimate Number : 12317  
 P.O. Number : *N/A* Part Number : D3473041  
 This Issue : 5/4/2006 S.O. No. : *N/A* Drawing Number : D3473 REV A  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : *N/A* Type : SMALL /MED FAB Drawing Revision : A  
 Previous Run : 26613 Material : *N/A*  
 Written By : Due Date : 5/28/2006 Qty: *8* Um: Each  
 Checked & Approved By : *06.05.05*  
 Comment : Est Rev: A New Issue 06-03-02 JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D3473043 BLOWER INLET WELDMENT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3473-043 INLET ADAPTER

*B26990*

2.0 D34709 BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3470-9 Bolt

*B24387*

3.0 AN960416 Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 AN960-416 Washer

*M5519*

4.0 AN3104 NUT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 AN310-4 Nut

*M19356*

*6*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLOWER INLET ADAPTER

Job Number: 26956

Part Number: D3473041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

MS24665153

COTTER PIN



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

COTTER PIN

Batch: M 19046

6.0

MS24665136

Cotter Pins



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 MS24665-136 Cotter Pin N 2421

7.0

D3474041

Inlet valve shaft



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3474-041 Inlet valve shaft B 26991

8.0

MS35206217

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 MS35206-217 Screw M 13883

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLOWER INLET ADAPTER

Job Number: 26956

Part Number: D3473041

Job Number:



Seq. #:

Machine Or Operation:

Description :

9.0

AN9604L

washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number Description Batch  
2 AN9604L Washer M14606

10.0

NAS679A04

NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number Description Batch  
2 NAS679A04 Nut M100551

11.0

D34747

BUTTERFLY VALVE SEAL



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch  
1 D3474-7 Valve Seal B24713

SB 06/07/10 ①

12.0

D34745

BUTTERFLY VALVE



Comment: Qty.: 2.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number Description Batch  
1 D3474-5 Valve Plate B26992

SB 06/07/10 ①

13.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble as per Dwg D3473

Ensure that Valve Assembly Opens & Closes Smoothly

SB 06/07/10 ①

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 06.08.09 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: 2 Date: 20/08/29  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Date: Thursday, 5/4/2006 11:14:10 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLOWER INLET ADAPTER

Job Number: 26956

Part Number: D3473041

Job Number:



Seq. #:

Machine Or Operation:

Description :

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with a permanent fine point marker and Stock

Location: GA

SB 06/08/23 (1)

16.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

106.08.24

Job Completion:



106.08.23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

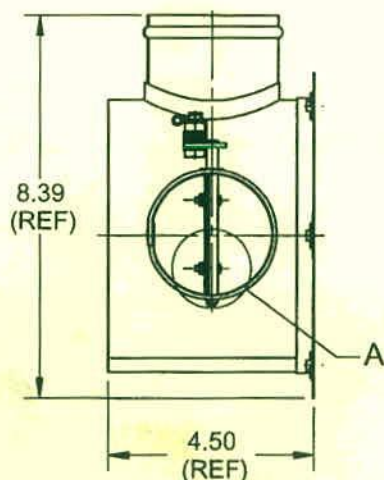
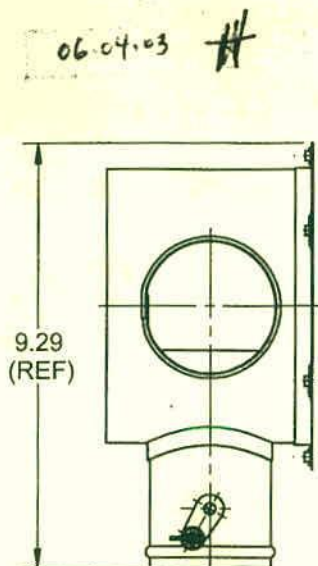
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

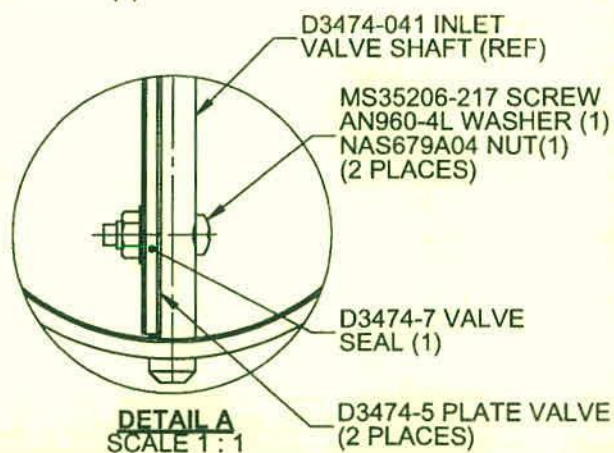
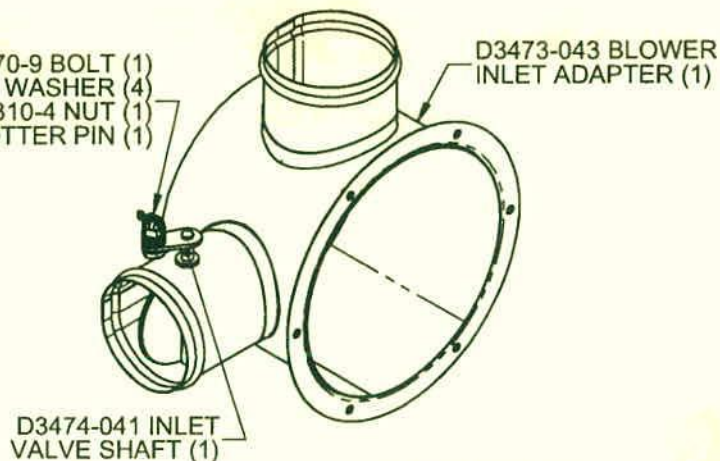


**DART**

DESIGN #	DRAWN BY #	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. <b>D3473</b>	REV. A SHEET 1 OF 7
DATE <b>06.02.07</b>		TITLE <b>BLOWER INLET ADAPTER</b>	SCALE 1:4
A	06.02.07	NEW ISSUE	



D3470-9 BOLT (1)  
AN960-416 WASHER (4)  
AN310-4 NUT (1)  
MS24665-153 COTTER PIN (1)



### D3473-041 BLOWER INLET ADAPTER

#### NOTES:

- 1) IDENTIFY WITH DART P/N D3473-041 USING FINE POINT PERMANENT INK MARKER
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -041	P/N	DESCRIPTION
X	D3473-041	BLOWER INLET ADAPTER
1	D3470-9	BOLT
1	D3471-043	BLOWER INLET WELDMENT
1	D3474-041	INLET VALVE SHAFT
2	D3474-5	BUTTERFLY VALVE
1	D3474-7	BUTTERFLY VALVE SEAL
1	AN310-4	NUT
2	AN960-4L	WASHER
4	AN960-416	WASHER
1	MS24665-153	COTTER PIN
2	MS35206-217	SCREW
2	NAS679-A04	NUT

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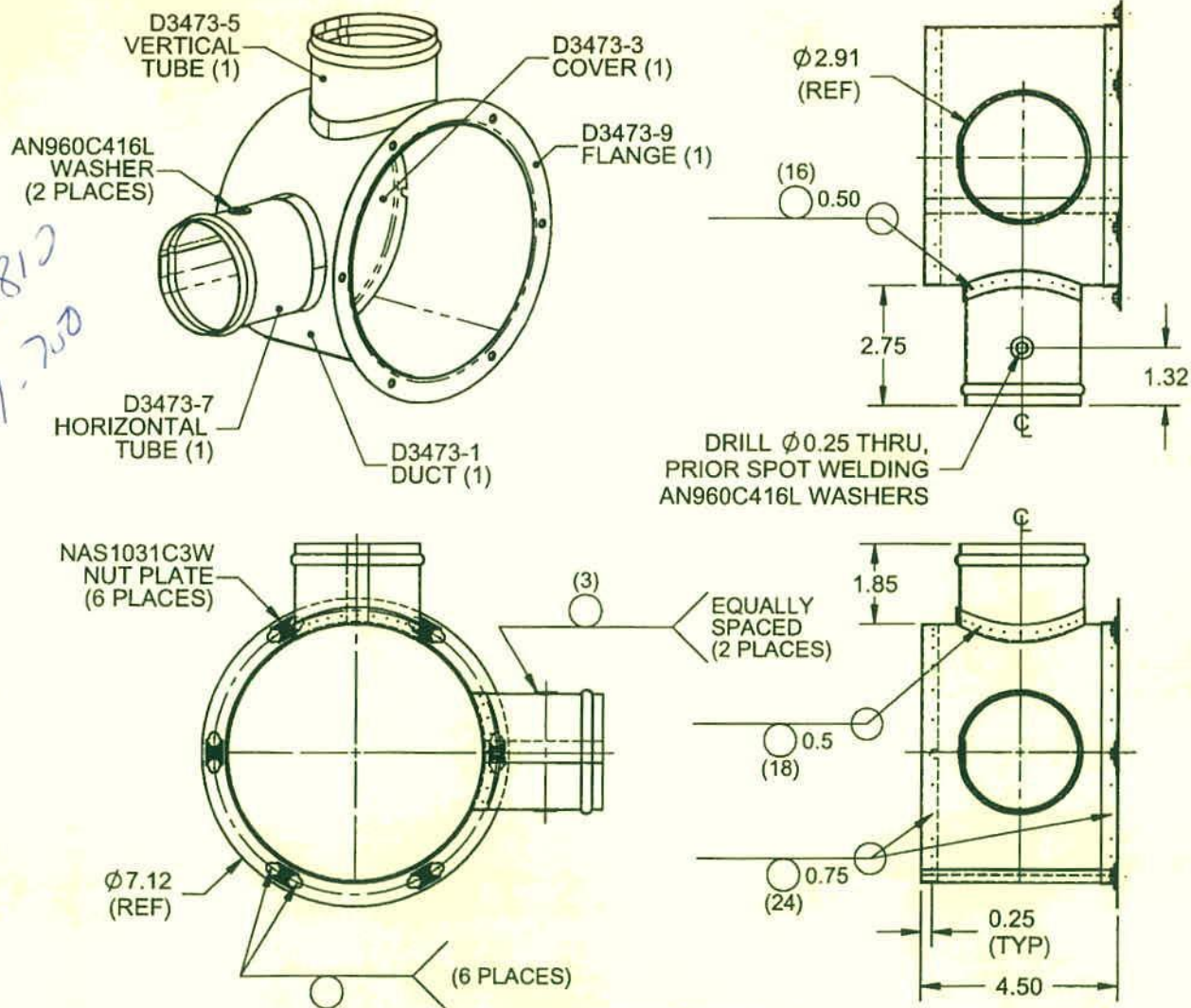




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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3473</b>	REV. A SHEET 2 OF 7
DATE <b>06.02.07</b>		TITLE <b>BLOWER INLET ADAPTER</b>	SCALE 1:4

RELEASED

06.04.03 *[Signature]***D3473-043 BLOWER INLET WELDMENT****NOTES:**

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -041	P/N	DESCRIPTION
X	D3473-043	BLOWER INLET WELDMENT
1	D3473-1	DUCT
1	D3473-3	COVER
1	D3473-5	VERTICAL TUBE
1	D3473-7	HORIZONTAL TUBE
1	D3473-9	FLANGE
2	AN960C416L	WASHER
6	NAS1031C3W	NUT PLATE

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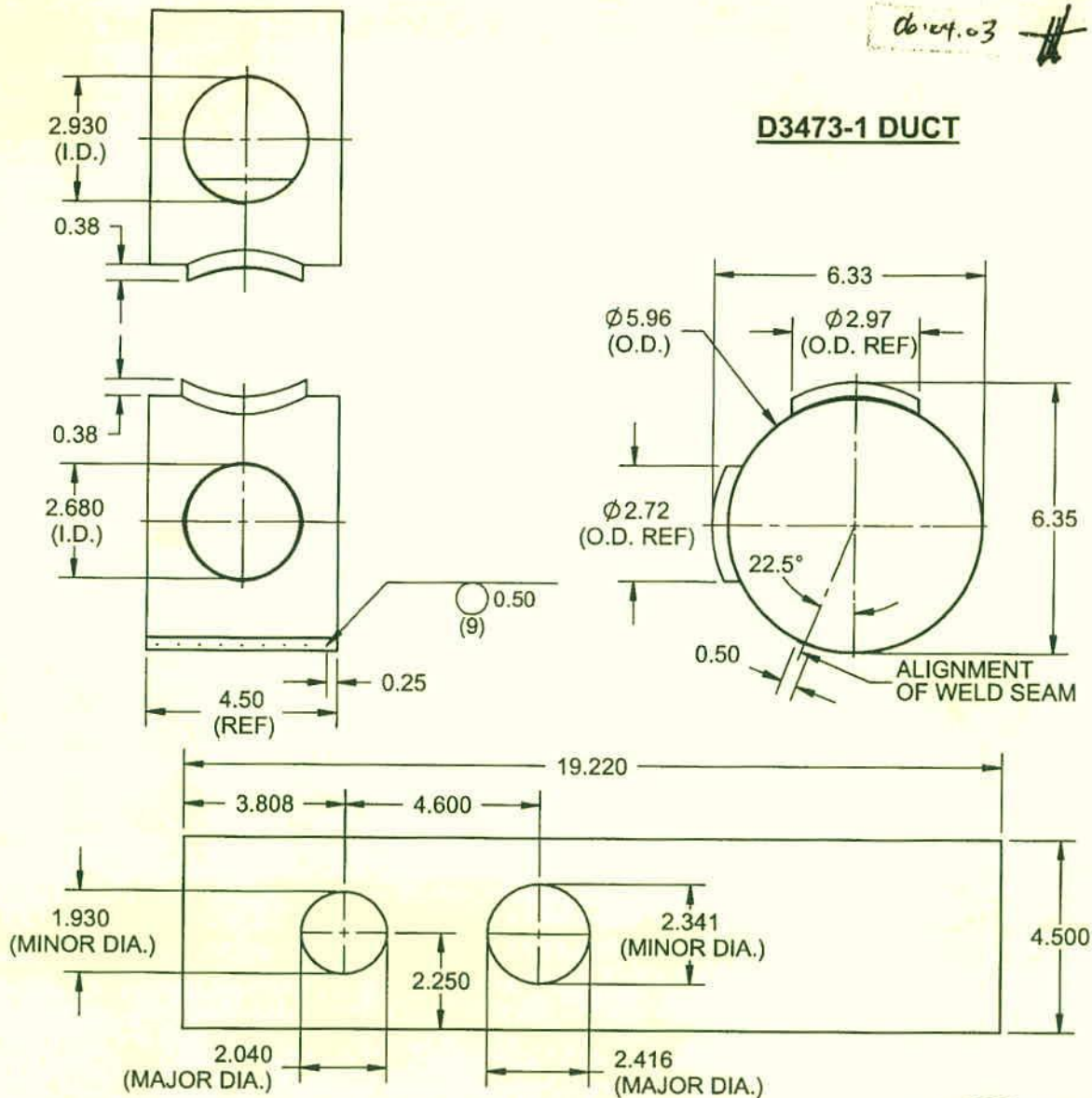
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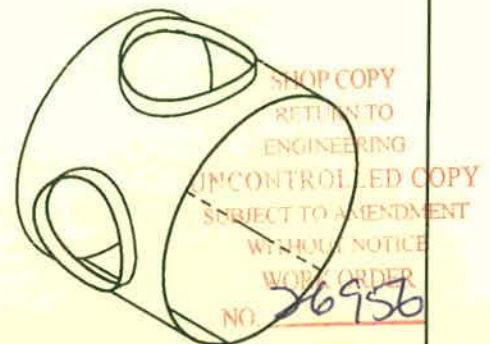


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DATE <b>06.02.07</b>		TITLE <b>BLOWER INLET ADAPTER</b>	SCALE 1:4

**D3473-1F DUCT FLAT PATTERN****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED)  
2B FINISH 26 GAUGE SS (0.018 THICK)
- 2) SPOT WELD PER DART QSI 004
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

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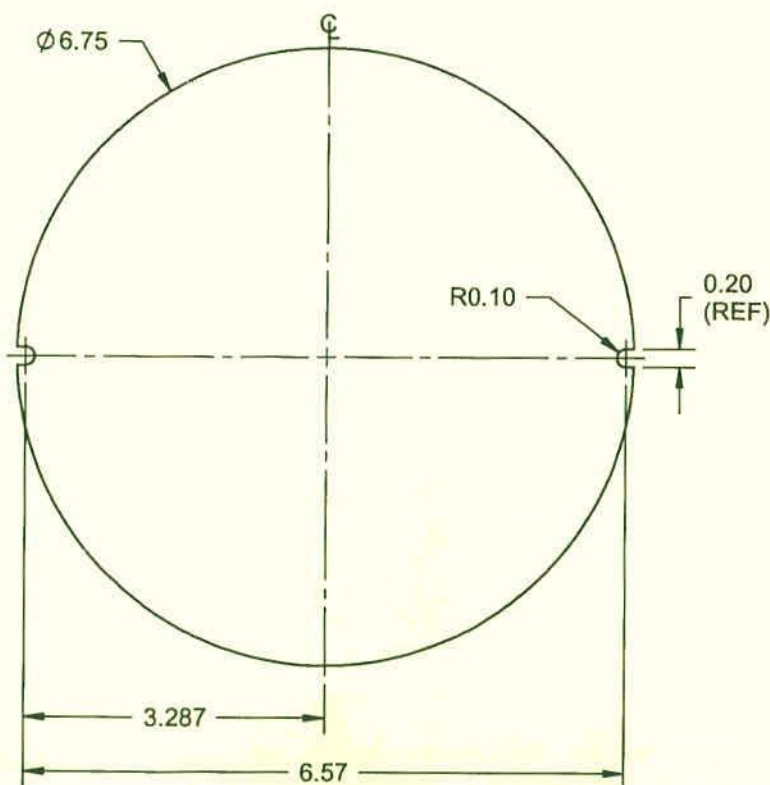
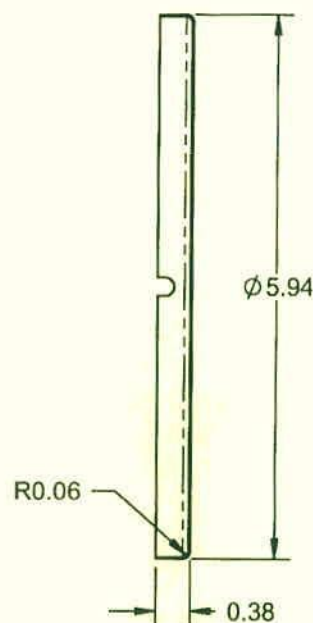




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DESIGN B	DRAWN BY B	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. <b>D3473</b>	REV. A SHEET 4 OF 7
DATE <b>06.02.07</b>		TITLE <b>BLOWER INLET ADAPTER</b>	SCALE 1:2

# 06.04.03

**D3473-3F COVER FLAT PATTERN****D3473-3 COVER****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH 26 GAUGE SS (0.018 THICK)
- 2) PART IS SYMMETRICAL ABOUT CENTERLINE
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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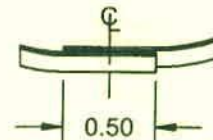
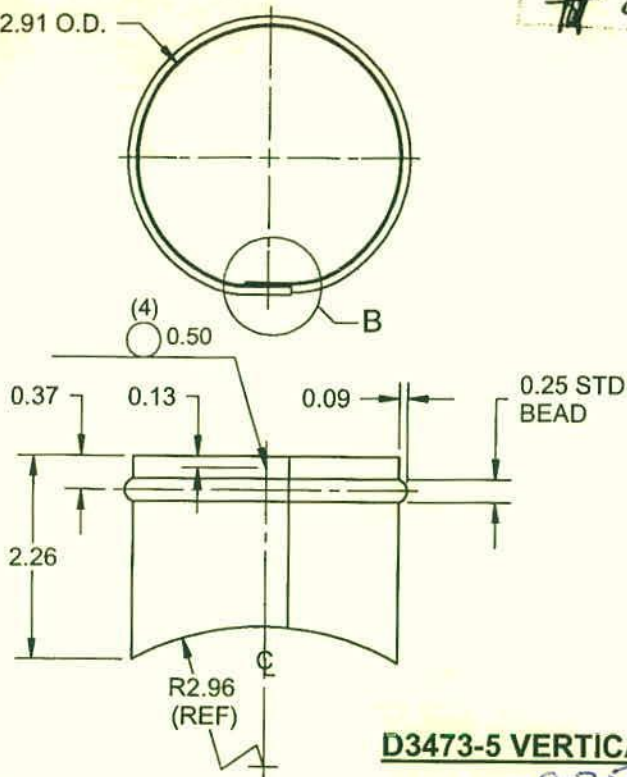
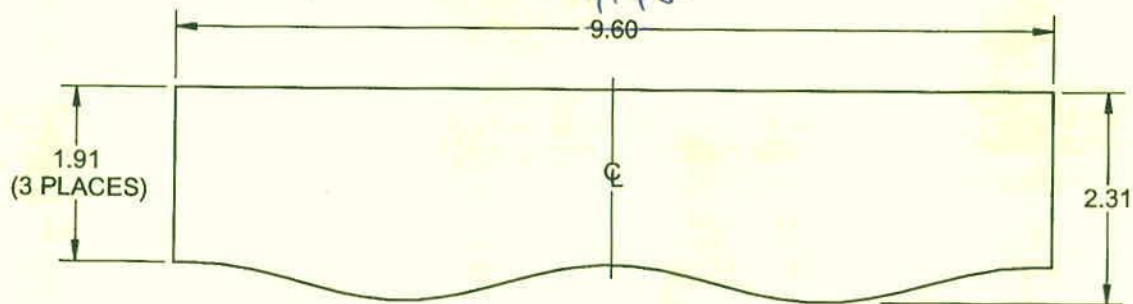




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DATE <b>06.02.07</b>		TITLE <b>BLOWER INLET ADAPTER</b>	SCALE 1:2

Ø2.91 O.D.

**DETAIL B**  
SCALE 1:1**D3473-5F VERTICAL TUBE FLAT PATTERN****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)
- 2) SPOT WELD PER DART QSI 004
- 3) FINISH: NONE
- 4) FLAT PATTERN IS SYMMETRICAL ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

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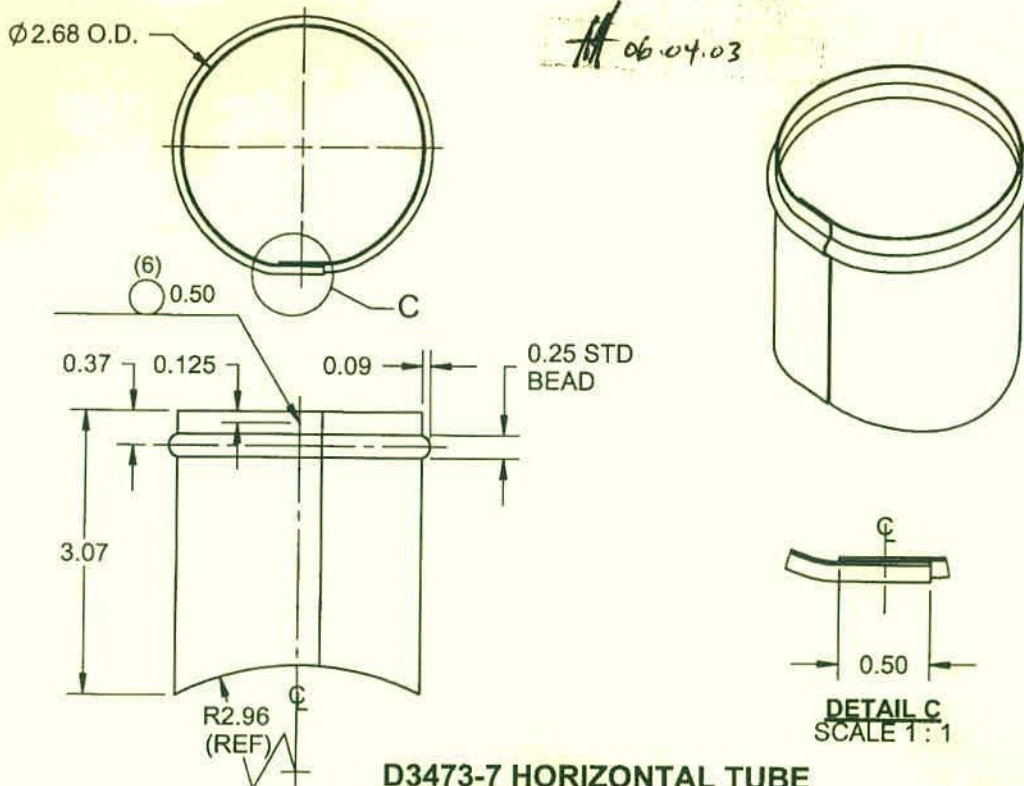
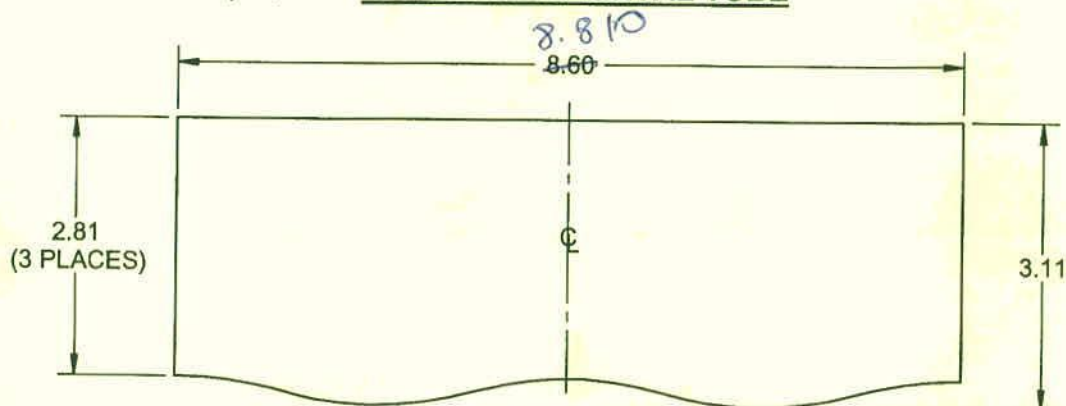
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DATE <b>06.02.07</b>		TITLE <b>BLOWER INLET ADAPTER</b>	SCALE 1:2

**D3473-7 HORIZONTAL TUBE****D3473-7F HORIZONTAL TUBE FLAT PATTERN****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)
- 2) SPOT WELD PER DART QSI 004
- 3) FINISH: NONE
- 4) FLAT PATTERN IS SYMMETRICAL ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

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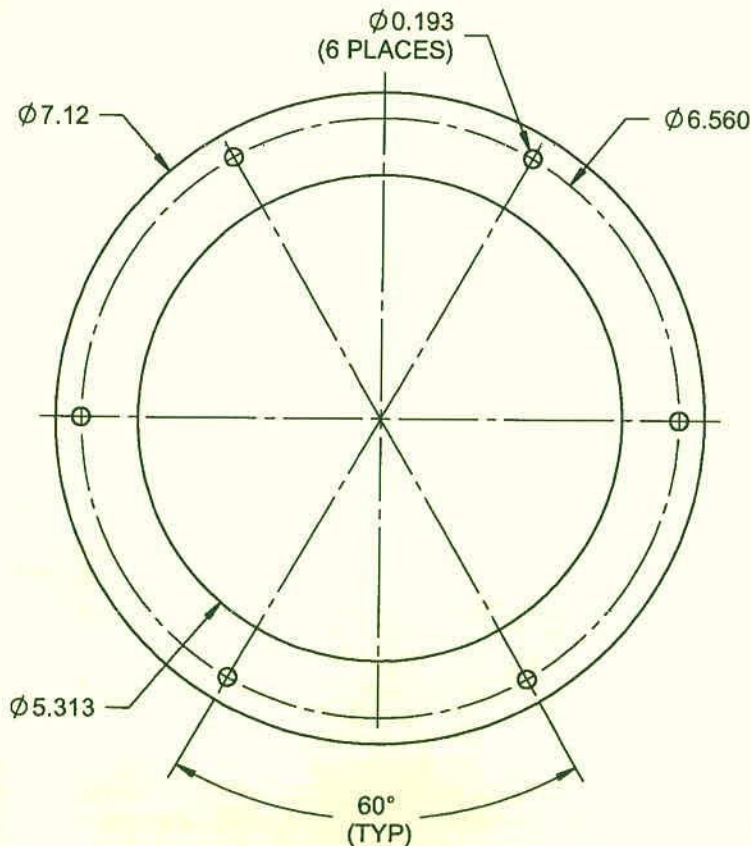




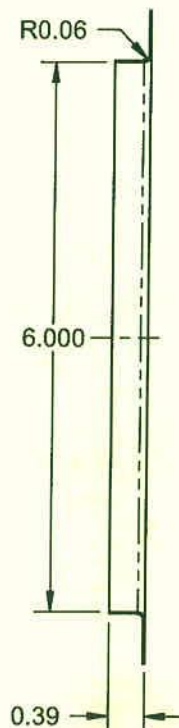


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DATE 06.02.07		TITLE BLOWER INLET ADAPTER	SCALE 1:2

*[Handwritten]* 06.04.03



**D3473-9F FLANGE FLAT PATTERN**



**D3473-9 FLANGE BENDING DETAIL**

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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